

SHIP 19/02

Dart Aerospace Ltd.

Date: Monday, 12/02/2007 9:42:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 30728		
Estimate Number	: 10437		
P.O. Number	: N/A	Part Number	: D33191
This Issue	: 12/02/2007	Drawing Number	: D3319 REV. B
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 29966	Material	: N/A
Written By	:	Due Date	: 19/02/2007
Checked & Approved By	:	Qty:	8
Comment	Um: Each Est: B 05.10.14 Added step 9, dwg rev B KJ/EC Est Rev:C Now on Waterjet 06-10-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
		Comment: Qty.: 0.6594 sf(s)/Unit Total : 5.2752 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: m102287 <i>m1 07 02 12</i> (8)
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: <u>B</u> <i>m1 07 02 12</i> (8) Prog Rev: <u>B</u>
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>m1 07 02 12</i> (8)
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>10/02/12</i> (8)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>SIB 07/02/12</i> (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/02/2007 9:42:59 AM
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Seq. #:

Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

- 1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B
2- Form flat on press using DT8776 block

SB 07/02/12

(8)

7.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J07-02-12 8

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod M103372

FC 07 02 13

(8)

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-02-13

(8)

10.0 POWDER COATING

POWDER COATING



M103371 m101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SL/YL

07/02/13

(8)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C 07/02/13 8

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXxxxx

For Product Eligibility see PDA05-18

and Stock

Location: _____

E 07/02/1980 E

Date: Monday, 12/02/2007 9:42:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30728

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

12/02/01

Job Completion

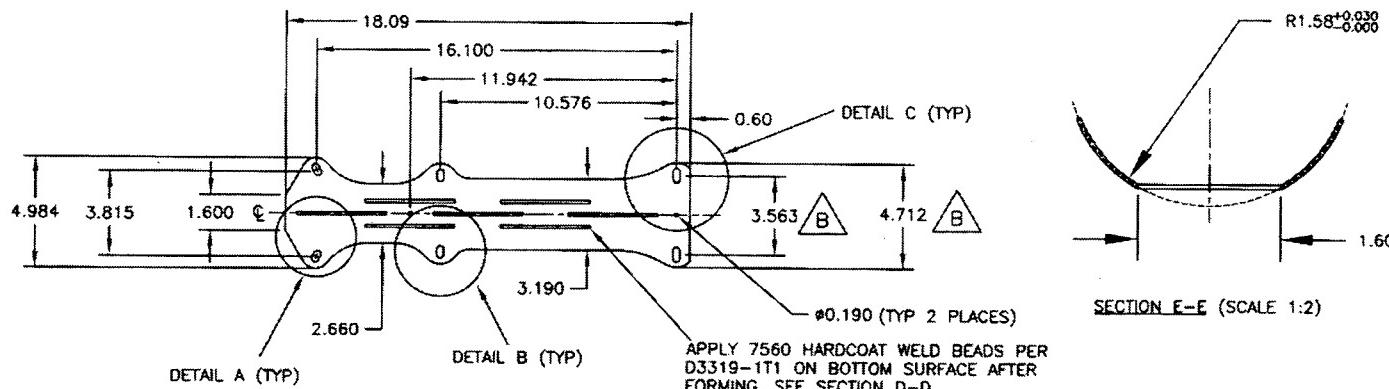


12/02/01

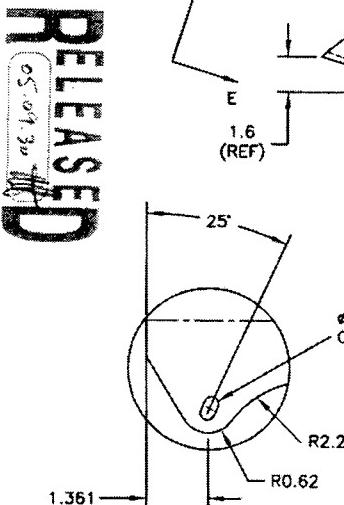


DESIGN		DART AEROSPACE LTD	
<u>P41</u>		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWN BY	<u>P41</u>	REV. B
H	APPROVED	H	SHEET 1 OF 5
DATE	DRAWING NO.	D3319	SCALE
05.06.06	TITLE	WEARPLATE	1:8
A	NEW ISSUE		
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7		

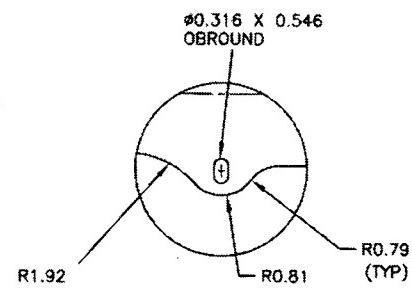
FLAT PATTERN



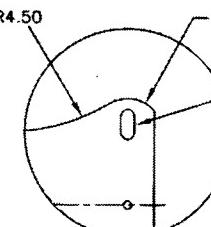
BENDING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)



DETAIL C

D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) PART IS SYMMETRICAL ABOUT CENTERLINE
5) ALL DIMENSIONS IN INCHES
6) WELD PER DART QSI 004
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART AEROSPACE LTD	Work Order:	30728
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	MJM
Date:	07.02.12

Audited by: DH

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	